

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:53:23 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 28452		
Estimate Number	: 10178	Part Number	: D25941
P.O. Number	: N/A	Drawing Number	: D2594 REV B1
This Issue	: 9/6/2006	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B1
First Issue	: N/A	Material	: N/A
Previous Run	: 28014	Due Date	: 9/30/2006
Written By	: <u>                    </u>	Qty:	96 Um: Each
Checked & Approved By	: <u>                    </u>		
Comment	: Est D 02.08.02 Make in Cobra KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total: 5.2517 f(s)  
Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
1100-0 (QQ-A-225/1) Ø0.625" Rod  
(M5052H32R0.625) or (M6061T6R0.625)

Batch 10/421-75.2517

                     96  
06-09-02

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
1-Make as per Dwg D2594-1 and Folio FA262.  
2-Break all sharp edges 0.010 max.

                     96  
06-09-02

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

                     96  
06-09-02

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

                     96  
06-09-02

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Acid etch and alodine as per QSI 005 4.1

Q.M 06-10-02

                     96  
06-10-02

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA ☒ Date: 06/10/03

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:53:23 PM  
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Drawing Name: PLUG

Job Number: 28452

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

am 06-10-02

(96)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 02

(96)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(96)

Comment: FINAL INSPECTION/W/O RELEASE

06/10/03

Job Completion



U 06-10-03

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

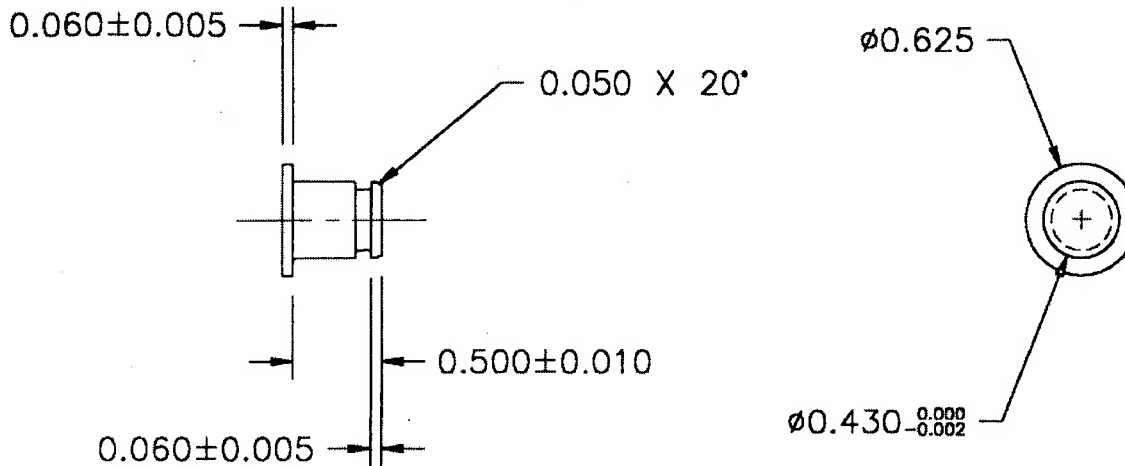




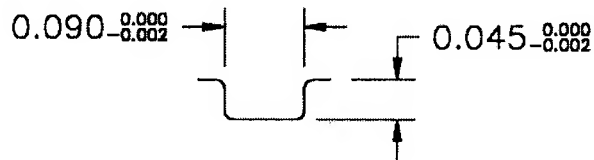
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	<del>RF</del> 02.08.26	ADD POWDER COAT, QSI 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED  
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSI COS 4.3

PER QQ-A-225 / 7 (5052)  
OR QQ-A-225 / 8 (6061)  
OR QQ-A-225 / 1 (1100)  
OR QQ-A-200 / 8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH  
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG  
(1) D2594-3 O-RING  
NO. 28452

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28452